

58617

Date: Monday, 18/08/2008 10:26:53 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 41287
Estimate Number : 12882
P.O. Number :
This Issue : 18/08/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 35404
Written By :
Checked & Approved By : JUL 08 8.18
Comment : Est Rev:A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD
Est Rev:C ECN1048 07-12-18 DD verified by: EC

Drawing Name : ARM
Part Number : D3560042
Drawing Number : D3560 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 10/09/2008

Qty: 10 Um: Each
(Handwritten: 4, 26)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)
6061-T6 Bar 0.50" x 5.00" *not in computer*
Batch: M109025

JL 08/08/25

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 16.750" long

JL 08/08/25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

DTP 08/08/26

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 08/08/26

(10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/09/02 (10)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
PLATE B 41083 ✓ SP 08.09.02. (4X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch (65 deg C) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

(Signature)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08.09.02 (4X)
08/09/05 (12)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 08-09-05

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

92 08-09-08 x2

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h 08/09/08

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Spacer

337113

08/09/08

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/09/08

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/08

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

08/09/08

16.0

QC21

FINAL INSPECTION/W/O RELEASE



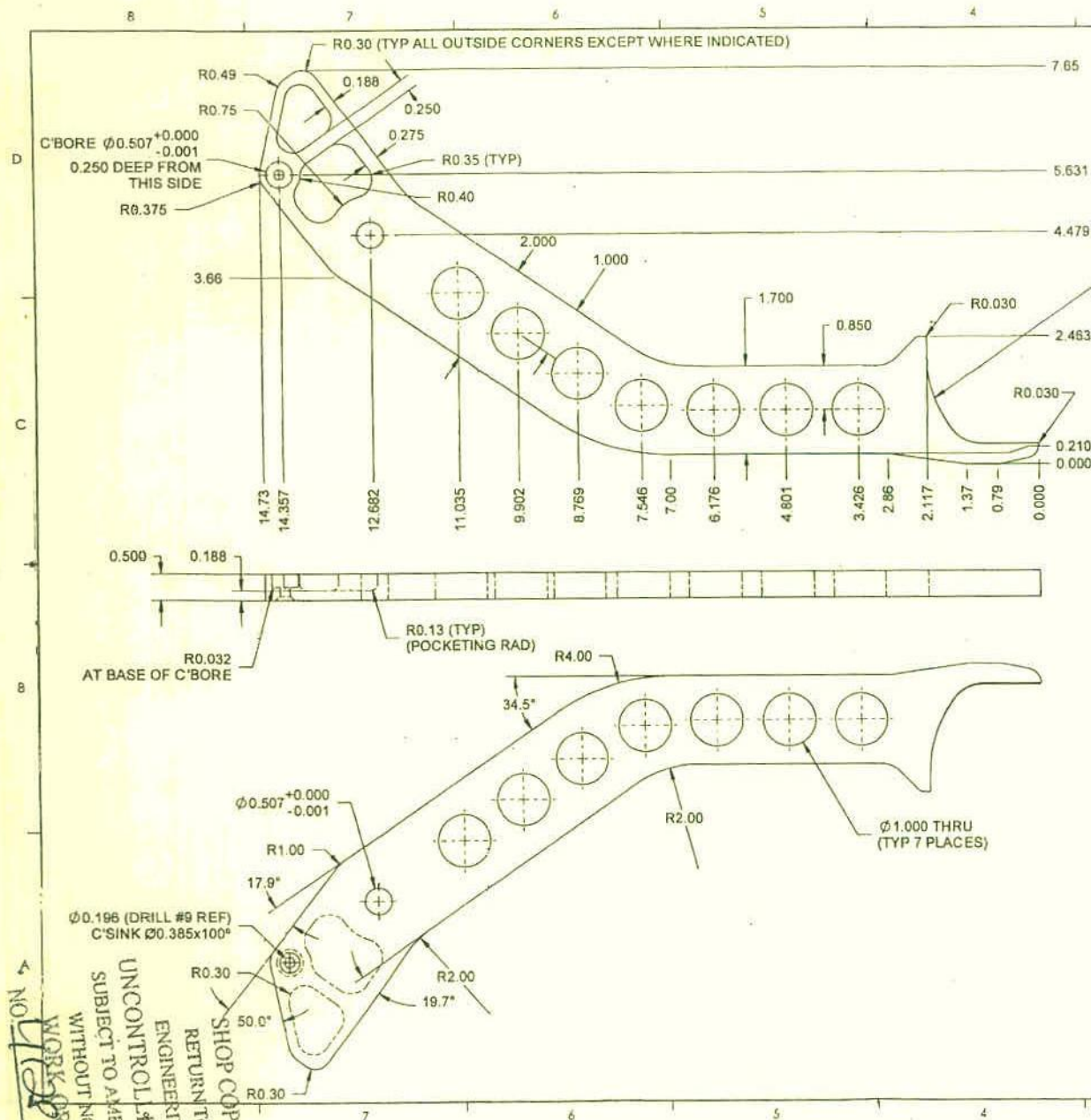
Comment: FINAL INSPECTION/W/O RELEASE

08/09/08

Job Completion



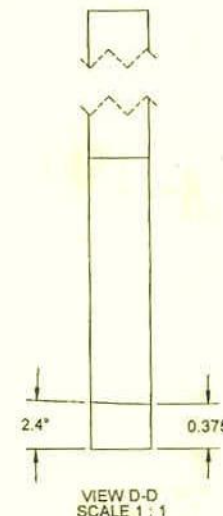
MF 08-09-08



RELEASED
07-12-14

D3560-2 ARM

- NOTES:**
- 1) MATERIAL: 6081-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN	07	DART AEROSPACE LTD	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO. D3560	REV. D
MFG. APPR.	MP	TITLE ARM WELDMENT	SHEET 3 OF 5
APPROVED	MP	SCALE 1:2	
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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